

20-8121



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**D3078-041**  
**Job Sheet 202548**



DAS  
24  
9-89

Part No: D3078-041

Job Qty: 2 pcs

Part Name: Step Assembly, Hi Short LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/30/19

Job Tracking No:

Due Date: 11/21/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP REV:A 15.11.12 NEW ISSUE DD VERF:JLM IPP REV:B 16.03.15 DWG REV.B DD  
VERF:JLM

Ship Via:

## Bill of Materials

## Job Routing

| Op No | Operation                 | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier      |  | Lead Time | Sign-off                                                                              |
|-------|---------------------------|-------|------------|----------|-----------|---------|--------------------------|--|-----------|---------------------------------------------------------------------------------------|
|       |                           |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier    |  |           |                                                                                       |
| 110   | Large Fab - Welded Assy-1 | 2 pcs | 11/21/19   |          | 0.00      | 2.02    | Large Fab - 1            |  |           |                                                                                       |
|       |                           |       |            |          |           |         | Large Fab - 10           |  |           |                                                                                       |
|       |                           |       |            |          |           |         | Large Fab - 2            |  |           |                                                                                       |
|       |                           |       |            |          |           |         | Large Fab - 3            |  |           |                                                                                       |
|       |                           |       |            |          |           |         | Large Fab - 4            |  |           |                                                                                       |
|       |                           |       |            |          |           |         | Large Fab - 5            |  |           |                                                                                       |
|       |                           |       |            |          |           |         | Large Fab - 6            |  |           |                                                                                       |
|       |                           |       |            |          |           |         | Large Fab - 7            |  |           |                                                                                       |
|       |                           |       |            |          |           |         | Large Fab - 8            |  |           |                                                                                       |
|       |                           |       |            |          |           |         | Large Fab - 9            |  |           |                                                                                       |
|       |                           |       |            |          |           |         | Large Fab - 11 (Various) |  |           |                                                                                       |
|       |                           |       |            |          |           |         | Large Fab - 12           |  |           |                                                                                       |
| 120   | QC 5                      | 2 pcs | 11/21/19   |          | 0.00      | 0.00    | QC 5 - 10                |  |           |  |
|       |                           |       |            |          |           |         | QC 5 - 12                |  |           |                                                                                       |
|       |                           |       |            |          |           |         | QC 5 - 17                |  |           |                                                                                       |
|       |                           |       |            |          |           |         | QC 5 - 18                |  |           |                                                                                       |
|       |                           |       |            |          |           |         | QC 5 - 19                |  |           |                                                                                       |
|       |                           |       |            |          |           |         | QC 5 - 22                |  |           |                                                                                       |
|       |                           |       |            |          |           |         | QC 5 - 24                |  |           |                                                                                       |
|       |                           |       |            |          |           |         | QC 5 - 3                 |  |           |                                                                                       |
|       |                           |       |            |          |           |         | QC 5 - 43                |  |           |                                                                                       |
|       |                           |       |            |          |           |         | QC 5 - 49                |  |           |                                                                                       |
|       |                           |       |            |          |           |         | QC 5 - 51                |  |           |                                                                                       |
|       |                           |       |            |          |           |         | QC 5 - 58                |  |           |                                                                                       |
|       |                           |       |            |          |           |         | QC 5 - 68                |  |           |                                                                                       |
|       |                           |       |            |          |           |         | QC 5 - 9                 |  |           |                                                                                       |
|       |                           |       |            |          |           |         | QC 5 - 50                |  |           |                                                                                       |
|       |                           |       |            |          |           |         | QC 5 - 30                |  |           |                                                                                       |
|       |                           |       |            |          |           |         | QC 5 - 40                |  |           |                                                                                       |
|       |                           |       |            |          |           |         | QC 5 - 61                |  |           |                                                                                       |



**Container No: S255479**  
  
**Part: D3078 - 041**  
**Job No: 202548**  
**Serial No/Batch: S255479**  
Revision:  
Inspector:  
Exp Date:  
Instructions: Various STC's

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K64 1K7  
CANADA  
TEL : 1 813 632-6200  
Email: sales@dartaero.com  
www.dartaerospace.com

Date: 02/13/20

**DAS**  
**81**  
**9-89**

FEB 18 2020



Container No: S255479



Part: D3078-041

Job No: 202548

Serial No/Batch: S255479

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL: 1 613 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

Date: 02/13/20

DAS  
81  
9-89

FEB 18 2020

Plex 10/30/19 11:37 AM Dart.lajeunesse.marie

P.T.O.

|                                   |       |          |                   |                                |             |
|-----------------------------------|-------|----------|-------------------|--------------------------------|-------------|
| 130 Large Fab - Welded Assy-2-B4B | 2 pcs | 11/21/19 | 0.00 2.02<br>3.00 | QC 5 - 81                      |             |
|                                   |       |          |                   | Large Fab - 1 - B4B            |             |
|                                   |       |          |                   | Large Fab - 10 - B4B           |             |
|                                   |       |          |                   | Large Fab - 2 - B4B            |             |
|                                   |       |          |                   | Large Fab - 3 - B4B            |             |
|                                   |       |          |                   | Large Fab - 4 - B4B            |             |
|                                   |       |          |                   | Large Fab - 5 - B4B            |             |
|                                   |       |          |                   | Large Fab - 6 - B4B            |             |
|                                   |       |          |                   | Large Fab - 7 - B4B            | 12          |
|                                   |       |          |                   | Large Fab - 8 - B4B            |             |
|                                   |       |          |                   | Large Fab - 9 - B4B            |             |
|                                   |       |          |                   | Large Fab - 11 - B4B (Various) |             |
|                                   |       |          |                   | Large Fab - 12 - B4B           |             |
| 140 QC 9                          | 2 pcs | 11/21/19 | 0.00 0.00         | QC 9 - 10                      |             |
|                                   |       |          |                   | QC 9 - 18                      |             |
|                                   |       |          |                   | QC 9 - 24                      | DAS 24 9-89 |
|                                   |       |          |                   | QC 9 - 43                      |             |
|                                   |       |          |                   | QC 9 - 50                      |             |
|                                   |       |          |                   | QC 9 - 9                       |             |
| 150 QC 5                          | 2 pcs | 11/21/19 | 0.00 0.00         | QC 5 - 10                      |             |
|                                   |       |          |                   | QC 5 - 12                      |             |
|                                   |       |          |                   | QC 5 - 17                      |             |
|                                   |       |          |                   | QC 5 - 18                      |             |
|                                   |       |          |                   | QC 5 - 19                      |             |
|                                   |       |          |                   | QC 5 - 22                      |             |
|                                   |       |          |                   | QC 5 - 24                      | DAS 24 9-89 |
|                                   |       |          |                   | QC 5 - 3                       |             |
|                                   |       |          |                   | QC 5 - 43                      |             |
|                                   |       |          |                   | QC 5 - 49                      |             |
|                                   |       |          |                   | QC 5 - 51                      |             |
|                                   |       |          |                   | QC 5 - 58                      |             |
|                                   |       |          |                   | QC 5 - 68                      |             |
|                                   |       |          |                   | QC 5 - 9                       |             |
|                                   |       |          |                   | QC 5 - 50                      |             |
|                                   |       |          |                   | QC 5 - 30                      |             |
|                                   |       |          |                   | QC 5 - 40                      |             |
|                                   |       |          |                   | QC 5 - 61                      |             |
|                                   |       |          |                   | QC 5 - 81                      |             |
| 160 Handfinish - 1-1 Chemical-B4B | 2 pcs | 11/21/19 | 0.00 0.23         | Handfinish - 1 - 1 - B4B       |             |
|                                   |       |          |                   | Handfinish - 1 - 2 - B4B       |             |
|                                   |       |          |                   | Handfinish - 1 - 3 - B4B       |             |
|                                   |       |          |                   | Handfinish - 1 - 4 - B4B       |             |
|                                   |       |          |                   | Handfinish - 1 - 5 - B4B       |             |
|                                   |       |          |                   | Handfinish - 1 - 6 - B4B       |             |
|                                   |       |          |                   | Handfinish - 1 - 7 - B4B       |             |
|                                   |       |          |                   | Handfinish - 1 - 8 - B4B       |             |
|                                   |       |          |                   | Handfinish - 1 - 9 - B4B       |             |
|                                   |       |          |                   | Handfinish - 1 - 10 - B4B      |             |
|                                   |       |          |                   | Handfinish - 1 - 11 - B4B      |             |
|                                   |       |          |                   | Handfinish - 1 - 12 - B4B      |             |
|                                   |       |          |                   | Handfinish - 1 - 13 - B4B      |             |
|                                   |       |          |                   | Handfinish - 1 - 14 - B4B      |             |
|                                   |       |          |                   | Handfinish - 1 - 15 - B4B      |             |
|                                   |       |          |                   | Handfinish - 1 - 16 - B4B      |             |
|                                   |       |          |                   | Handfinish - 1 - 17 - B4B      |             |
|                                   |       |          |                   | Handfinish - 1 - 18 - B4B      |             |
|                                   |       |          |                   | Handfinish - 1 - 19 - B4B      |             |
|                                   |       |          |                   | Handfinish - 1 - 20 - B4B      |             |

|                                   |          |          |           |                                   |                                                                                       |
|-----------------------------------|----------|----------|-----------|-----------------------------------|---------------------------------------------------------------------------------------|
|                                   |          |          |           | Handfinish - 1 - 21 - B4B         |                                                                                       |
|                                   |          |          |           | Handfinish - 1 - 22 - B4B         |                                                                                       |
| 170 QC 7                          | 2<br>pcs | 11/21/19 | 0.00 0.00 | QC 7 - 10                         |                                                                                       |
|                                   |          |          |           | QC 7 - 13                         |                                                                                       |
|                                   |          |          |           | QC 7 - 14                         |                                                                                       |
|                                   |          |          |           | QC 7 - 15                         |                                                                                       |
|                                   |          |          |           | QC 7 - 17                         |                                                                                       |
|                                   |          |          |           | QC 7 - 18                         |                                                                                       |
|                                   |          |          |           | QC 7 - 19                         |                                                                                       |
|                                   |          |          |           | QC 7 - 2                          |                                                                                       |
|                                   |          |          |           | QC 7 - 28                         |                                                                                       |
|                                   |          |          |           | QC 7 - 3                          |                                                                                       |
|                                   |          |          |           | QC 7 - 30                         |                                                                                       |
|                                   |          |          |           | QC 7 - 34                         |                                                                                       |
|                                   |          |          |           | QC 7 - 36                         |                                                                                       |
|                                   |          |          |           | QC 7 - 37                         |                                                                                       |
|                                   |          |          |           | QC 7 - 41                         |                                                                                       |
|                                   |          |          |           | QC 7 - 47                         |                                                                                       |
|                                   |          |          |           | QC 7 - 48                         |                                                                                       |
|                                   |          |          |           | QC 7 - 51                         |                                                                                       |
|                                   |          |          |           | QC 7 - 58                         |                                                                                       |
|                                   |          |          |           | QC 7 - 59                         |                                                                                       |
|                                   |          |          |           | QC 7 - 60                         |                                                                                       |
|                                   |          |          |           | QC 7 - 9                          |                                                                                       |
|                                   |          |          |           | QC 7 - 68                         |                                                                                       |
|                                   |          |          |           | QC 7 - 50                         |                                                                                       |
|                                   |          |          |           | QC 7 - 67                         |                                                                                       |
|                                   |          |          |           | QC 7 - 40                         |                                                                                       |
|                                   |          |          |           | QC 7 - 24                         | DAS                                                                                   |
|                                   |          |          |           | QC 7 - 43                         | 43                                                                                    |
|                                   |          |          |           | QC 7 - 61                         | 9-88                                                                                  |
|                                   |          |          |           | QC 7 - 81                         |                                                                                       |
|                                   |          |          |           | QC 7 - 76                         |                                                                                       |
|                                   |          |          |           | QC 7 - 79                         |                                                                                       |
| 200 Large Fab - Welded Assy-3-B4B | 2<br>pcs | 11/21/19 | 0.00 2.02 | Large Fab - 1 - B4B               |  |
|                                   |          |          |           | Large Fab - 10 - B4B              |                                                                                       |
|                                   |          |          |           | Large Fab - 2 - B4B               |                                                                                       |
|                                   |          |          |           | Large Fab - 3 - B4B               |                                                                                       |
|                                   |          |          |           | Large Fab - 4 - B4B               |                                                                                       |
|                                   |          |          |           | Large Fab - 5 - B4B               |                                                                                       |
|                                   |          |          |           | Large Fab - 6 - B4B               |                                                                                       |
|                                   |          |          |           | Large Fab - 7 - B4B               |                                                                                       |
|                                   |          |          |           | Large Fab - 8 - B4B               |                                                                                       |
|                                   |          |          |           | Large Fab - 9 - B4B               |                                                                                       |
|                                   |          |          |           | Large Fab - 11 - B4B<br>(Various) |                                                                                       |
|                                   |          |          |           | Large Fab - 12 - B4B              |                                                                                       |
| 210 QC 10                         | 2<br>pcs | 11/21/19 | 0.00 0.00 | QC 10 - 10                        |                                                                                       |
|                                   |          |          |           | QC 10 - 18                        |                                                                                       |
|                                   |          |          |           | QC 10 - 24                        | DAS                                                                                   |
|                                   |          |          |           | QC 10 - 43                        | 24                                                                                    |
|                                   |          |          |           | QC 10 - 50                        | 9-89                                                                                  |
|                                   |          |          |           | QC 10 - 58                        |                                                                                       |
|                                   |          |          |           | QC 10 - 9                         |                                                                                       |
|                                   |          |          |           | QC 10 - 68                        |                                                                                       |
| 220 QC 5                          | 2<br>pcs | 11/21/19 | 0.00 0.00 | QC 5 - 10                         |                                                                                       |
|                                   |          |          |           | QC 5 - 12                         |                                                                                       |
|                                   |          |          |           | QC 5 - 17                         |                                                                                       |
|                                   |          |          |           | QC 5 - 18                         |                                                                                       |

Plex 10/30/19 11:37 AM Dart.lajeunesse.marie

|                                        |          |          |           |                                              |                   |
|----------------------------------------|----------|----------|-----------|----------------------------------------------|-------------------|
|                                        |          |          |           | QC 5 - 19                                    |                   |
|                                        |          |          |           | QC 5 - 22                                    |                   |
|                                        |          |          |           | QC 5 - 24                                    |                   |
|                                        |          |          |           | QC 5 - 3                                     |                   |
|                                        |          |          |           | QC 5 - 43                                    |                   |
|                                        |          |          |           | QC 5 - 49                                    |                   |
|                                        |          |          |           | QC 5 - 51                                    |                   |
|                                        |          |          |           | QC 5 - 58                                    |                   |
|                                        |          |          |           | QC 5 - 68                                    |                   |
|                                        |          |          |           | QC 5 - 9                                     |                   |
|                                        |          |          |           | QC 5 - 50                                    |                   |
|                                        |          |          |           | QC 5 - 30                                    |                   |
|                                        |          |          |           | QC 5 - 40                                    |                   |
|                                        |          |          |           | QC 5 - 61                                    |                   |
|                                        |          |          |           | QC 5 - 81                                    |                   |
| 240 Handfinish - 6-1- Touch Up-<br>B4B | 2<br>pcs | 11/21/19 | 0.00 0.23 | Handfinish - 6 - 1 - B4B                     | BET 20-04-15      |
|                                        |          |          |           | Handfinish - 6 - 2 - B4B                     |                   |
|                                        |          |          |           | Handfinish - 6 - 3 - B4B                     |                   |
|                                        |          |          |           | Handfinish - 6 - 4 - B4B                     |                   |
|                                        |          |          |           | Handfinish - 6 - 5 - B4B                     |                   |
|                                        |          |          |           | Handfinish - 6 - 6 - B4B                     |                   |
|                                        |          |          |           | Handfinish - 6 - 7 - B4B                     |                   |
|                                        |          |          |           | Handfinish - 6 - 8 - B4B                     |                   |
|                                        |          |          |           | Handfinish - 6 - 9 - B4B                     |                   |
|                                        |          |          |           | Handfinish - 6 - 10 - B4B                    |                   |
|                                        |          |          |           | Handfinish - 6 - 11 - B4B                    |                   |
|                                        |          |          |           | Handfinish - 6 - 12 - B4B                    |                   |
|                                        |          |          |           | Handfinish - 6 - 13 - B4B                    |                   |
|                                        |          |          |           | Handfinish - 6 - 14 - B4B                    |                   |
|                                        |          |          |           | Handfinish - 6 - 15 - B4B                    |                   |
|                                        |          |          |           | Handfinish - 6 - 16 - B4B                    |                   |
|                                        |          |          |           | Handfinish - 6 - 17 - B4B                    |                   |
|                                        |          |          |           | Handfinish - 6 - 18 - B4B                    |                   |
|                                        |          |          |           | Handfinish - 6 - 19 - B4B                    |                   |
|                                        |          |          |           | Handfinish - 6 - 20 - B4B                    |                   |
|                                        |          |          |           | Handfinish - 6 - 21 - B4B                    |                   |
|                                        |          |          |           | Handfinish - 6 - 22 - B4B                    |                   |
| 250 Powdercoat - 1 White Gl(A)-<br>B4B | 2<br>pcs | 11/21/19 | 0.00 0.46 | Powdercoat - 1 - B4B                         |                   |
|                                        |          |          |           | Powdercoat - 2 - B4B                         |                   |
|                                        |          |          |           | Powdercoat - 3 - B4B                         | 20-04-16- 23 9-89 |
|                                        |          |          |           | Powdercoat - 4 - B4B                         |                   |
| 260 Handfinish - 3-1- WingWalk-<br>B4B | 2<br>pcs | 11/21/19 | 0.00 0.23 | Handfinish - 3 - 1 - B4B                     |                   |
|                                        |          |          |           | Handfinish - 3 - 2 - B4B                     |                   |
|                                        |          |          |           | Handfinish - 3 - 3 - B4B                     |                   |
|                                        |          |          |           | Handfinish - 3 - 4 - B4B                     | 20-04-16. 23 9-89 |
|                                        |          |          |           | Handfinish - 3 - 5 - B4B                     |                   |
| 270 QC 3                               | 2<br>pcs | 11/21/19 | 0.00 0.00 | QC 3 - 10                                    |                   |
|                                        |          |          |           | QC 3 - 13                                    |                   |
|                                        |          |          |           | QC 3 - 15                                    |                   |
|                                        |          |          |           | QC 3 - 17                                    |                   |
|                                        |          |          |           | QC 3 - 18                                    |                   |
|                                        |          |          |           | QC 3 - 2                                     |                   |
|                                        |          |          |           | QC 3 - 28                                    |                   |
|                                        |          |          |           | QC 3 - 3                                     |                   |
|                                        |          |          |           | QC 3 - 30                                    |                   |
|                                        |          |          |           | QC 3 - 34                                    |                   |
|                                        |          |          |           | QC 3 - 36                                    |                   |
|                                        |          |          |           | QC 3 - 41                                    |                   |
|                                        |          |          |           | QC 3 - 51                                    |                   |
|                                        |          |          |           | Plex 10/30/19 11:37 AM Dart.lajeunesse.marie |                   |

|     |                             |          |          |           |                   |                        |                          |
|-----|-----------------------------|----------|----------|-----------|-------------------|------------------------|--------------------------|
|     |                             |          |          | QC 3 - 58 |                   |                        |                          |
|     |                             |          |          | QC 3 - 59 |                   |                        |                          |
|     |                             |          |          | QC 3 - 68 |                   |                        |                          |
|     |                             |          |          | QC 3 - 9  |                   |                        |                          |
|     |                             |          |          | QC 3 - 40 |                   |                        |                          |
|     |                             |          |          | QC 3 - 19 |                   |                        |                          |
|     |                             |          |          | QC 3 - 43 | DAS<br>81<br>9-89 |                        |                          |
|     |                             |          |          | QC 3 - 24 |                   |                        |                          |
|     |                             |          |          | QC 3 - 61 |                   |                        |                          |
|     |                             |          |          | QC 3 - 81 |                   |                        |                          |
| 290 | Packaging 3-1 - Stock - B4B | 2<br>pcs | 11/21/19 | 0.00      | 0.00              | Packaging 3 - 1 - B4B  |                          |
|     |                             |          |          |           |                   | Packaging 3 - 2 - B4B  |                          |
|     |                             |          |          |           |                   | Packaging 3 - 3 - B4B  |                          |
|     |                             |          |          |           |                   | Packaging 3 - 4 - B4B  |                          |
|     |                             |          |          |           |                   | Packaging 3 - 5 - B4B  |                          |
|     |                             |          |          |           |                   | Packaging 3 - 6 - B4B  |                          |
|     |                             |          |          |           |                   | Packaging 3 - 7 - B4B  |                          |
|     |                             |          |          |           |                   | Packaging 3 - 8 - B4B  |                          |
|     |                             |          |          |           |                   | Packaging 3 - 9 - B4B  |                          |
|     |                             |          |          |           |                   | Packaging 3 - 10 - B4B |                          |
|     |                             |          |          |           |                   | Packaging 3 - 11 - B4B |                          |
|     |                             |          |          |           |                   | Packaging 3 - 12 - B4B |                          |
|     |                             |          |          |           |                   | Packaging 3 - 13 - B4B |                          |
|     |                             |          |          |           |                   | Packaging 3 - 14 - B4B |                          |
|     |                             |          |          |           |                   | Packaging 3 - 15 - B4B |                          |
|     |                             |          |          |           |                   | Packaging 3 - 16 - B4B |                          |
|     |                             |          |          |           |                   | Packaging 3 - 17 - B4B |                          |
|     |                             |          |          |           |                   | Packaging 3 - 18 - B4B |                          |
|     |                             |          |          |           |                   | Packaging 3 - 19 - B4B |                          |
|     |                             |          |          |           |                   | Packaging 3 - 20 - B4B |                          |
|     |                             |          |          |           |                   | Packaging 3 - 21 - B4B |                          |
|     |                             |          |          |           |                   | Packaging 3 - 22 - B4B |                          |
|     |                             |          |          |           |                   | Packaging 3 - 23 - B4B |                          |
|     |                             |          |          |           |                   | Packaging 3 - 24 - B4B |                          |
|     |                             |          |          |           |                   | Packaging 3 - 25 - B4B | DAS<br>72<br>9-89        |
|     |                             |          |          |           |                   | Packaging 3 - 26 - B4B |                          |
|     |                             |          |          |           |                   | Packaging 3 - 27 - B4B |                          |
|     |                             |          |          |           |                   | Packaging 3 - 28 - B4B |                          |
|     |                             |          |          |           |                   | Packaging 3 - 29 - B4B |                          |
|     |                             |          |          |           |                   | Packaging 3 - 30 - B4B |                          |
|     |                             |          |          |           |                   | Packaging 3 - 31 - B4B |                          |
|     |                             |          |          |           |                   | Packaging 3 - 32 - B4B |                          |
|     |                             |          |          |           |                   | Packaging 3 - 33 - B4B |                          |
|     |                             |          |          |           |                   | Packaging 3 - 34 - B4B |                          |
|     |                             |          |          |           |                   | Packaging 3 - 35 - B4B |                          |
|     |                             |          |          |           |                   | Packaging 3 - 36 - B4B |                          |
| 300 | QC 21 - SA                  | 2<br>pcs | 11/21/19 | 0.00      | 0.00              | QC 21 - SA - 21        |                          |
|     |                             |          |          |           |                   | QC 21 - SA - 70        |                          |
|     |                             |          |          |           |                   | QC 21 - SA - 53        | DAS<br>21<br>APR 24 2020 |

Part Op 110 - (Fabricate per Dwg) 1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078 2-Drill extrusion as per Dwg Descriptions: D3078 using Jig DT6680 for rivets. 3-Debur

120 - QC5- Inspect part completeness to step on W/O

130 - (Weld per dwg A/R Aluminum rod Batch: 313401) 1-Bevel end for welding FWD ONLY 2-Weld Support, weld Fwd End Plate as per QSI 004 & Dwg D3072 A/R Aluminum Rod 3-Grind End Plate flush

140 - (QC9- Inspect visual per QSI004- Fusion Welds)

150 - QC5- Inspect part completeness to step on W/O)

160 - (Chemical Conversion Coat per QSI005 4.1)

170 - (QC7-Inspect Chemical Conversion Coat)

200 - (Weld per dwg A/R Aluminum rod Batch: ) 1- Rivet Leg Assembly as per Dwg D3078. 2-Bevel Aft end for welding 3-Inspect for foreign object as per QSI 024 4-Weld Aft End Plate as per QSI 004 & Dwg D3078 A/R Aluminum Rod 5-Grind End Plate flush

210 - (QC10- Inspect visual per QSI004- ground welds)

220 - (QC5- Inspect part completeness to step on W/O)

240 - (Touch up alodine)

250 - (White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum) START TIME: 7:55 MSH469 OVEN TEMPERATURE: 300°FINISH TIME: 8:25260 - (Wing Walk as per dwg QSI005 4.4 Batch M209623)

270 - (QC3- Inspect Part Finish)

290 - (Identify as per dwg &amp; Stock Location: \_\_\_\_\_)

300 - (QC21- Final Inspection - Work Order Release)

## Job BOM

| Part / Item   | Component Name    | Quantity      | Operation                          | Container      |
|---------------|-------------------|---------------|------------------------------------|----------------|
| D2622-120C    | Step Extrusion    | 1 pcs (.5 ea) | 110-Large Fab - Welded Assy-1      | <u>5243427</u> |
| D3067-1       | End Plate         | 4 pcs (2 ea)  | 130-Large Fab - Welded Assy-2- B4B | <u>5246961</u> |
| D3219-3       | Plate             | 4 pcs (2 ea)  | 130-Large Fab - Welded Assy-2- B4B | <u>5207480</u> |
| D3065-041     | Step Leg Assembly | 2 pcs (1 ea)  | 200-Large Fab - Welded Assy-3- B4B | <u>5267483</u> |
| D3066-1       | Spacer            | 4 pcs (2 ea)  | 200-Large Fab - Welded Assy-3- B4B | <u>5264205</u> |
| MS20600-AD4W4 | Rivet             | 32 Ea (16 ea) | 200-Large Fab - Welded Assy-3- B4B | <u>5253658</u> |

## Job Allocations

| Operation                          | Component Part | Required | Inventory | Allocated |
|------------------------------------|----------------|----------|-----------|-----------|
| 110-Large Fab - Welded Assy-1      | D2622-120C     | 1        | 105       | 0         |
| 130-Large Fab - Welded Assy-2- B4B | D3067-1        | 4        | 61        | 0         |
|                                    | D3219-3        | 4        | 46        | 0         |
| 200-Large Fab - Welded Assy-3- B4B | D3065-041      | 2        | 8         | 0         |
|                                    | D3066-1        | 4        | 74        | 0         |
|                                    | MS20600-AD4W4  | 32       | 615       | 0         |

## Part Specifications

Specifications could not be found.

Plex 10/30/19 11:37 AM Dart.lajeunesse.marie

Entered: 1RDate: 2020-06-12  
20/02/20

## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 20-8121Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                 |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  |                                               |  |  |  |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-----------------------------------------------|--|--|--|
| Job: <u>202548</u><br>Part No. <u>D3078-041</u>                                                                                                                                                                                                                                                                                                                                                 |  | <b>DISPOSITION</b><br>Rework <input type="checkbox"/><br>Scrap <input checked="" type="checkbox"/><br>Use-as-is <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  | <b>DEPARTMENT/PROCESS</b><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input checked="" type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div> |  |                                               |  |  |  |
| Date: <u>20/02/20</u>                                                                                                                                                                                                                                                                                                                                                                           |  | Sequence #: <u>130</u>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  | QTY Affected: <u>1</u>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  | MRB (QSI042)<br>DAS 55<br>9-89<br>FEB 20 2020 |  |  |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |  | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |  |                                               |  |  |  |
| <u>lugs WERE POSITIONED WRONG ON STEP</u><br><br><br><u>OPERATOR ERROR.</u>                                                                                                                                                                                                                                                                                                                     |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |  | <u>SCRAP &amp; DESTROY</u>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |                                               |  |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                 |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |  | Completed By<br><u>MAC</u><br>Lead hand / Supervisor<br>DAS 24<br>9-89<br><u>20/02/20</u>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |                                               |  |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                 |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |  | QC / QA Coordinator<br>DAS 55<br>9-89<br>FEB 20 2020                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  |                                               |  |  |  |
| <b>Root Cause</b><br>Operator <input checked="" type="checkbox"/><br>Manufacturing Process <input type="checkbox"/><br>Equip/Tooling <input type="checkbox"/><br>Handling/Presservation <input type="checkbox"/><br>Material <input type="checkbox"/><br>Product Improvement <input type="checkbox"/><br>Process Improvement <input type="checkbox"/><br>Human Factors <input type="checkbox"/> |  | <b>FAULT CATEGORY</b><br><div style="display: flex; justify-content: space-between;"> <div> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> <div> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div> <input checked="" type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  |                                               |  |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                 |  | Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  |                                               |  |  |  |